




# MACHINING CONDITIONS

DNGG 150604 NS LT 05

T0004403

Material Group		Material Example	Hardness	D.O.C		Feed		Amax	Vc		Advised D.O.C	Advised Feed	Advised Vc	
				min[mm]	max[mm]	min[mm/t]	max [mm/t]	[mm <sup>2</sup> ]	min [m/min]	max [m/min]	[mm]	[mm/t]	[m/min]	
Aluminium	Al (<8%Si)	13	4% < Si < 8%	100 HB	0.3	5.5	0.1	0.3	1.4	250	600	2.5	0.23	300
			Si < 4%	60 HB	0.3	5.5	0.12	0.35	1.8	400	1200	2.5	0.23	400
	Copper Alloys	14	CuZn30	100 HB	0.3	5.5	0.1	0.3	1.4	150	800	2.5	0.23	250
	Non-Metallic	15	Fiber Plastics	-	0.3	5.5	0.1	0.2	1.4	70	500	2	0.15	150
			Graphite	-	0.3	5.5	0.1	0.2	1.4	100	200	2	0.15	150
Hard Rubber			-	0.3	5.5	0.1	0.2	1.4	80	300	2	0.15	150	